

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-022709**Date Inspected:** 05-Mar-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See Below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

Summary of Items Observed: On this date Caltrans OSM Quality Assurance (QA) Inspector, Mike Hasler was present during the times noted above for observations and testing relative to the work being performed.

**Bay 3**

This QA inspector performed a random observation for the OBG. During the observation performed it was noted ZPMC was in process of welding weld repair on Architectural Housing subassembly AH3150-002. ZPMC QC inspector Zhang Ya Xu was present at this time of this observation and informed this QA inspector of the work that is in process and identified Zhu Tian Shu as the CWI. It was stated that ZPMC had 1 welder and identified the welder by ZPMC welder identification number appointed to then by ZPMC. This QA inspector verified this information for the following location;

WR20318

Weld- AH3150-002

WPS-345-SMAW-1G(1F)-Repair

Welder-058102

1G/CJP/FCAW

**Bay 11**

This QA inspector performed a random observation for the OBG. During the observation performed it was noted that at Bay 11 ZPMC was in process of welding. ZPMC QC inspector Shao Hai Lang was present at this time of this observation and informed this QA inspector of the work that is in process and identified Zhao Chen Sun as the

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CWI. It was stated that ZPMC had 3 welders and identified the welders by ZPMC welder identification number appointed to then by ZPMC. This QA inspector verified this information for the following location;

Weld-32TR2-016, 015, 012, 005, 004, 001

WPS-B-T-2231-ESAB

Welder-053316, 040785

1G/FCAW/CJP

Weld-30TR2-001, 004, 005, 015, 012, 016

WPS-B-T-2231-ESAB

Welder- 040785

1G/FCAW/CJP

Bay 10

This QA inspector observed ZPMC in process of welding and heat straightening. ZPMC CWI Guo Yan Fei was present at this time of this observation and informed this QA inspector of the work that is in process. It was stated that ZPMC had 5 welders and identified the welders by ZPMC welder identification number appointed to then by ZPMC. This QA inspector verified this information for the following location;

Weld Repair Per ZPMC UT-20330

Weld- TR-039-009, 011, 013, 015, 017

WPS-345-SMAW-2G(2F)-Repair

Welder- 500363, 040511, 052493, 057258

1G/SMAW/CJP

Weld-BK17C-001-031

WPS-B-T-2133-ESAB

Welder-057266

3F/FCAW

Cantilever Box

Heat Straightening

HSR1 (B) 10129

BK009A

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

### Summary of Conversations:

“As noted within the contents of this report.”

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact James Devey 1500026784, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Hasler, Mike	Quality Assurance Inspector
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<b>Reviewed By:</b>	Riley, Ken	QA Reviewer
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